














## Profiled Cutter incl. limiters Ø280 Z4

A16-210

The woodworking profiled cutter head with alternately inclined cutting edges and limiting profile is ground in one setup. The tool has 4 cutting edges, each of them has a steel limiting plate. In Quinto the tool is handled as 4 concatenated tools, 2 for the carbide profile and 2 for the limiting plate. Each of them is individually probed.



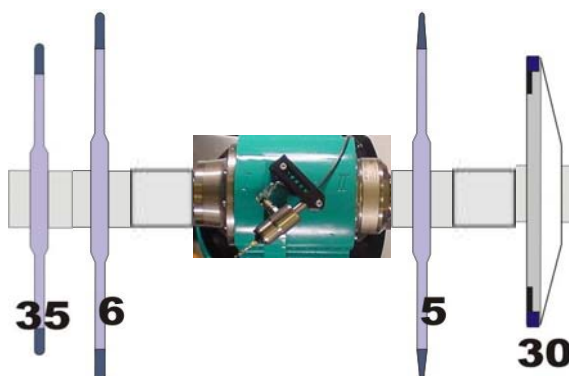
### 1. Cycletime for Production

Tool specifications Ø280, altern. Shear angles 10/-10°, L25 mm Material CARBIDE							
Operations							
Probe	2000	65	60	70	90	60	90
Feed [mm/Min]		65	60	70	90	60	90
Power [kW]		4	2	1	1	1	1
Cutting feed [m/s]		18	24	24	24	32	32
Used wheels							
Grinding time [s]	32	507	359	342	311	357	318
Total cycle time	37 Min 5						

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

### 2. Used Grinding Wheels

30 Ø150 12C9 D64  
6 Ø200 14F1 D64  
5 Ø200 14EE1 D64  
35 Ø150 14F1 B126



### 3. Machine and Software Requirements

Machines: 5 axes CNC grinders : CORVUS GDS, GEMINI DMR, NORMA CFG  
Control: Fanuc 160i  
Coolant: Synthetic Oil, pressure 6 - 7 bar  
Software: Quinto 4.3, DXQ

responsible engineer: OP,8.1.08

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